

Date: Tuesday, 2/28/2006 10:48:03 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : K10003
Job Number : 26006	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : K10003
This Issue : 2/28/2006 S.O. No. : N/A	Drawing Number : REWORK SADDLES
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/28/2006 Type : N/A	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : <u>SEE ABOVE USER & DATE</u>	Due Date : 3/7/2006 Qty: 1 Um: Each
Checked & Approved By : <u>11 11 11 11</u>	
Comment : <u>NCR 021</u>	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

REWORK SADDLES - FILE EDGE OF KEYWAY

PER DRWG D2571 DETAIL 5 REV.F

PER DRWG D2572 DETAIL 4 REV.F

PER DRWG D2573 DETAIL 5 REV.F

PER DRWG D2574 DETAIL 4 REV.4

FROM D205-634-011:

B24420 -- K10003 B D2571, B 24125/72, B 24125/73, B 23508/74, B 24126
 B24421 - K10003 B D2571, B 23508/72, B 24125/73, B 24126/74, B 24126
 B24422 - K10003 B D2573, B 23509/71, B 24125/72, B 24125/74, B 24126
 B24423 - K10003 B D2571, B 24125/72, B 24125/73, B 24126/74, B 24126
 B24424 - K10003 B D2571, B 24125/72, B 24125/73, B 23802/74, B 24126
 B24425 - K10003 B D2571, B 24125/72, B 24125/73, B 24126/74, B 24126

2.0

K10003

D205-634-011 Saddle Kit



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

D205-634-011 Saddle Kit

JB 06/03/01

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-01

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

TOUCH UP WITH ALODINE AS NECESSARY AS PER QSI 005 4.1

06-03-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: SD Date: 06/04/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/28/2006 10:48:03 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: K10003

Job Number: 26006

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

RE-POWDER COAT PER RS10004

06/03/06 30

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-04-06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE AND IDENTIFY K10003 WITH NEW BATCH NUMBER Rev. G

REPACKAGE INTO CORRESPONDING D205-634-011 SKIDTUBES PER PPP D205-634-011 Rev. G

06/04/07

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

06/04/07

Job Completion



06-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

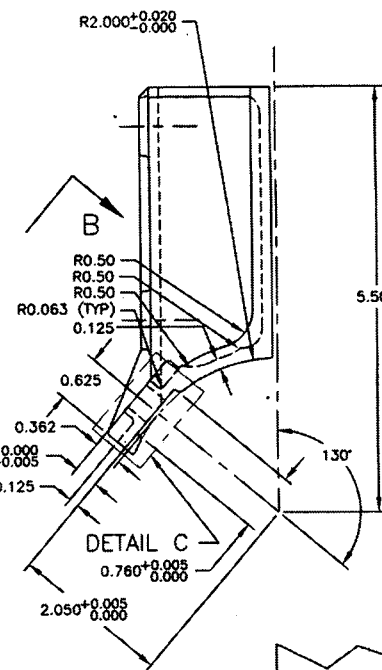
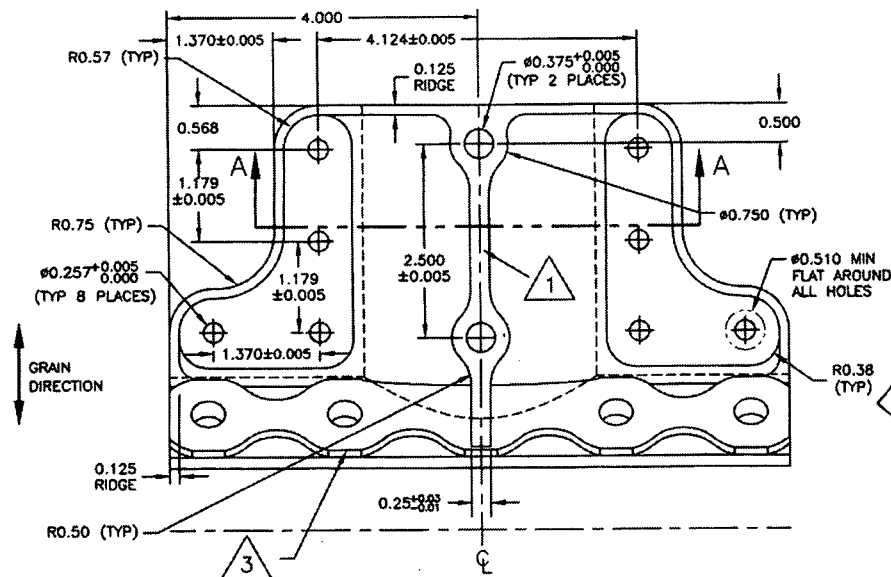
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

05.12.06



DETAIL C

0.760±0.005/0.000

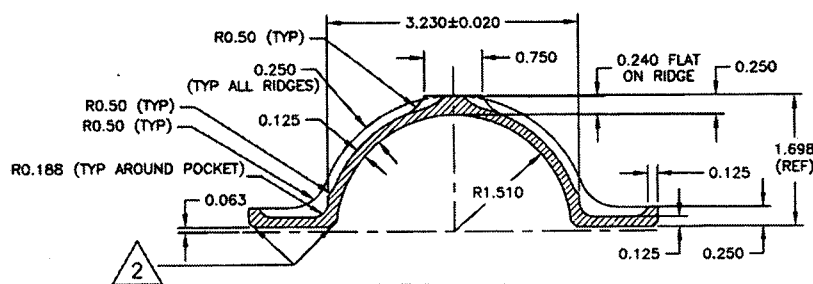
2.050±0.005/0.000

0.438±0.005/0.000 (TYP 4 PLACES)

0.500

R0.025 (REF. TYP)

DETAIL C SCALE 2:1



SECTION A-A

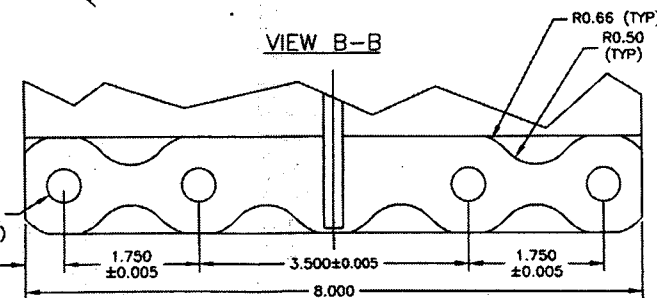
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

VIEW B-B









E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HARBORVIEW, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D2574
DATE	05.07.13	TITLE	INNER AFT SADDLE		
				REV. E	SHEET 1 OF 1
				SCALE	2:3

REFERENCE ONLY

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

VIEW B-B

1.73

0.20

2

R0.66 (TYP)

R0.50 (TYP)

DART

1.750 ± 0.005

3.500 ± 0.005

1.750 ± 0.005

8.000

[illegible]

DETAIL C
SCALE 4:3

DETAIL C
SCALE 4:3

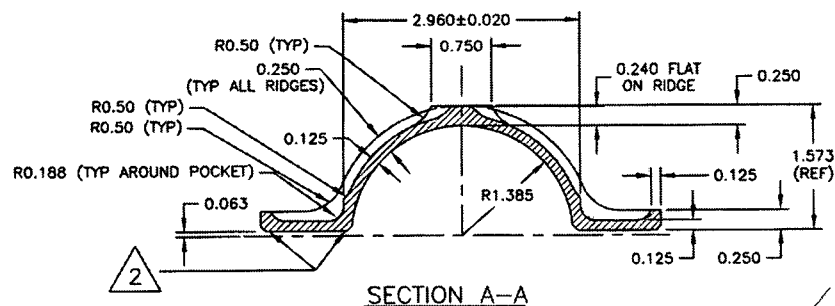
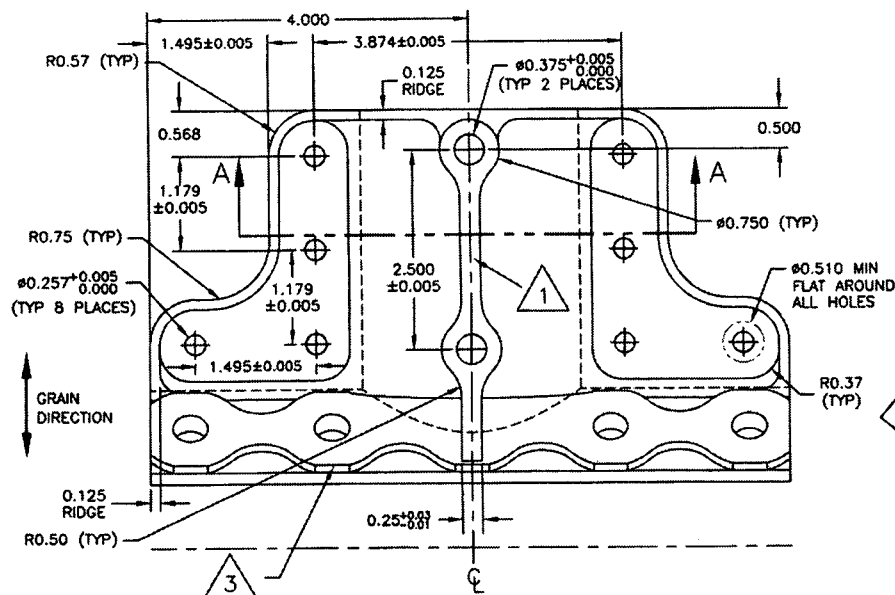
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DESIGN	DRAWN BY	NEW ISSUE	
DS	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2573	REV. SHEET 1 OF 2
DATE 05.07.13	TITLE OUTER AFT SADDLE		SCALE 2:

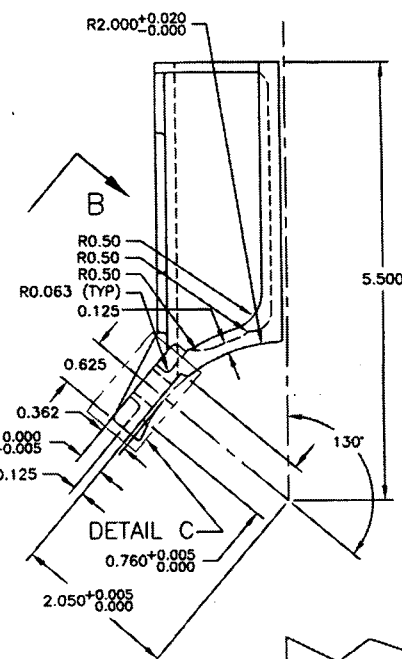
REFERENCE ONLY

RELEASED

05.12.06



SECTION A-A

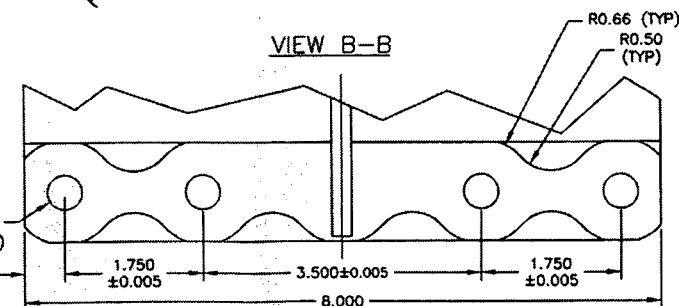
DETAIL C
SCALE 2:1Ø0.438±0.005
(TYP 4 PLACES)0.060
R0.025 (TYP)
4 (TYP)

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B

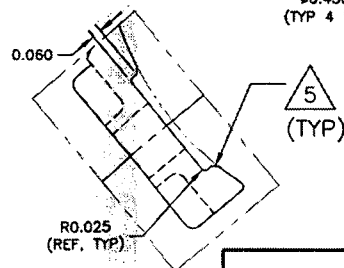
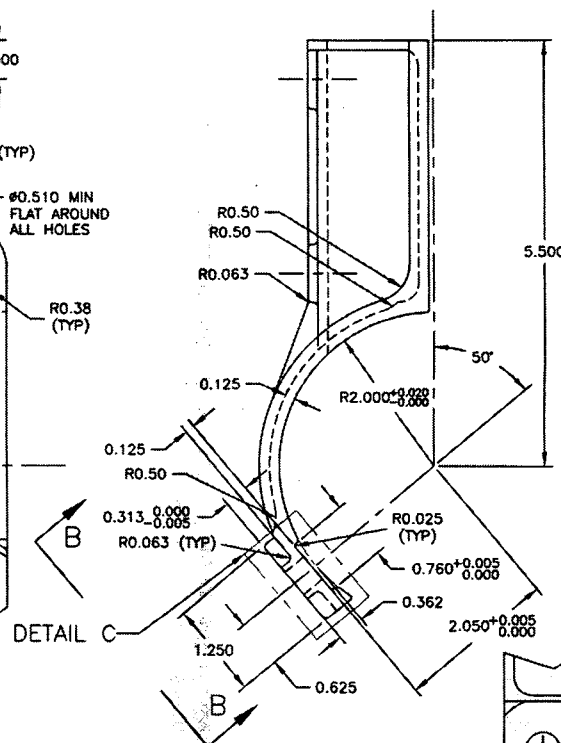
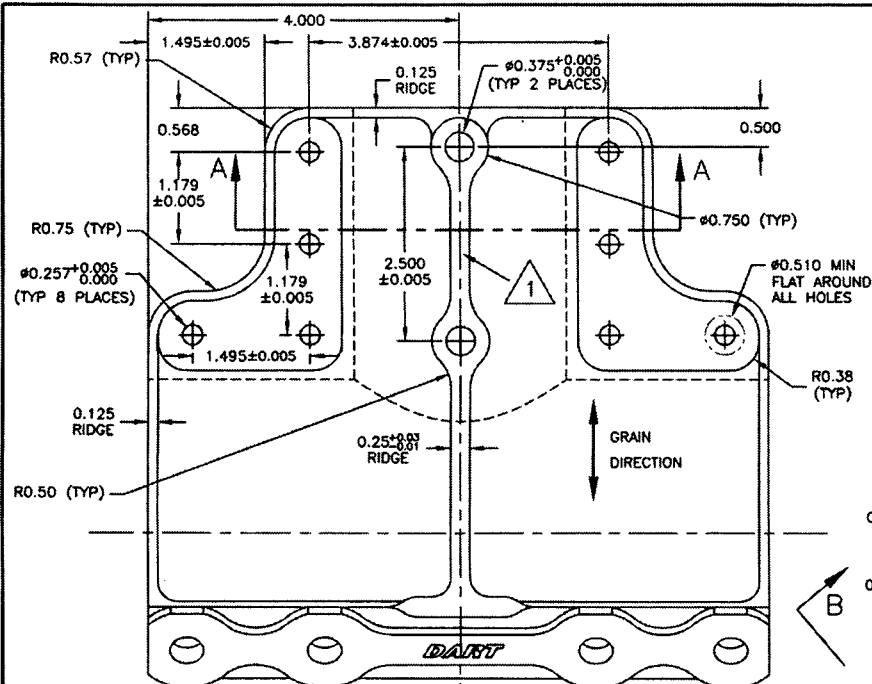


E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE
		DART AEROSPACE LTD. WARRICKSURY, OXFORD, ENGLAND
		DRAWING NO. D2572
		REV. E
		SHEET 1 OF 1
		SCALE 2:3

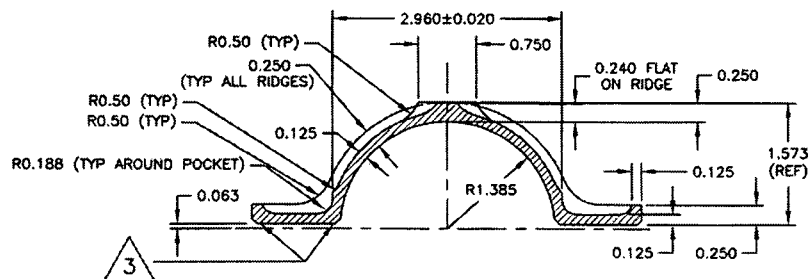
REFERENCE ONLY

RELEASED

05-12-06



DETAIL C
SCALE 4:3



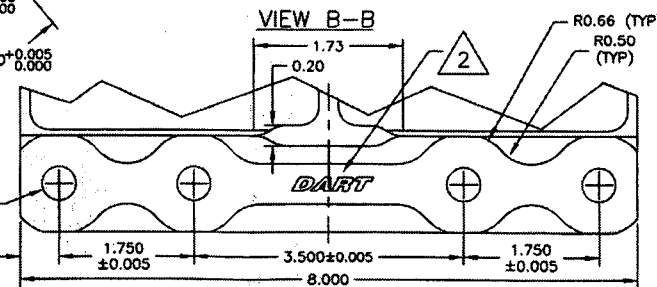
SECTION A-A

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.	REV. E
CHECKED	#	APPROVED	#	D2571	WARRICK, ONTARIO, CANADA	SHEET 1 OF 1
DATE	05.07.13	TITLE	OUTER FWD SADDLE	SCALE	2:3	

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